

HEAT FUSION OF ENDOT PE 3408 PIPE & TUBING

Endot Industries recommends using the times and temperatures listed below for the heat fusion of Endot pipe to other pipe or fittings produced from PE 3408 material. The actual times may need to be adjusted for varying weather conditions such as wind, rain, cold or heat, etc

HEAT FUSION TIME FOR PE 3408 PIPE AND TUBING AT A TEMPERATURE OF 500° F

TIME IN SECONDS

SIZE	BUTT FUSION	COOLING TIME	SOCKET FUSION	COOLING TIME
CTS				
3/4"	8 - 10	50	9 - 10	30
1"	14 - 17	50	11 - 13	30
1-1/4"	16 - 19	50	14 - 16	30
1-1/2"	18 - 21	60	16 - 18	40
2"	22 - 25	60	18 - 20	40
IPS				
1/2"	8 - 10	50	9 - 10	30
3/4"	14 - 16	50	12 - 14	30
1"	16 - 19	50	15 - 17	40
1-1/4"	18 - 21	70	17 - 20	40
1-1/2"	24 - 30	90	20 - 23	40
2"	30 - 34	90	24 - 27	40

CAUTION: Excessive heating times can over heat the pipe or fitting and result in brittle joints. Shortened heating times can result in an incomplete bond of materials and a weak joint that may fail.

Endot Industries does not recommend fusion of Endot pipe and tubing to materials of a different grade or specification or material classified as "Wide Spec". Fusion joints between dissimilar material may fail even when the time and temperature settings are correct.